



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

D3913-041
Job Sheet 168954-A



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/27/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

000337

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/4/18	0.00	0.00	Start Up Large Fab-2		SC 2018-01-29
100	Large Fab	1 pcs		1/4/18	0.00	10.00	Large Fab 1		11-18-1-18
110	QC	1 pcs		1/4/18	0.00	0.00	QC9		CPC
120	QC	1 pcs		1/4/18	0.00	0.00	QC5		CPC
125	HandFinish	1 pcs		1/4/18	0.00	0.29	HandFinish2		BP 18-01-31
130	Powdercoat	1 pcs		1/4/18	0.00	0.93	Powdercoat2		BP 18-01-31
135	Packaging	1 pcs		1/4/18	0.00	0.00	Packaging1		M 18-02-01
140	QC	1 pcs		1/4/18	0.00	0.00	QC3		M 18-02-01
150	HandFinish	1 pcs		1/5/18	0.00	0.50	HandFinish4		M 18-02-01
160	QC	1 pcs		1/5/18	0.00	0.00	QC5		AK 18-2-1
170	Packaging	1 pcs		1/5/18	0.00	0.00	Packaging3		M 18-02-01
180	QC21-SA	1 Ea		1/5/18	0.00	0.00	QC21		MCS FEB 01 2016

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 18-4-67. START: 11:50 O.V.T: 375°. FINISH: 12:05.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 5005842	2	77	0	0
	D3913-1 5018470	1	6	0	0
	D3913-15 5014390	1	2	0	0
	D3913-3 5018474	1	9	0	0
	D3913-7 5009710	2	23	0	0
	D3913-9 5030824	1	15	0	0
	D3916-041 5015623	2	2	0	0
	D3916-5 5026219	3	19	0	0
	D4016-1 8034748	3	44	0	0
	D4017-7 5012929	3	51	0	0
	D4017-9 5009723	2	24	0	0
	D4020-11 5016763	2	6	0	0
	D4021-1 5010955	3	55	0	0



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



☐ Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

150-HandFinish	D4034-041	5030318	1	2	0	0
	D4034-043		1	2	0	0
	D4672-	5005866	2	41	0	0
	M304EX0.75-16F	5021100	33	572	0	0
	AN3-10A	5000660	6	178	0	0
	D2931	F 86435-1	2	1,200	0	0
	D4021-5	504383	2	9	0	0
	MS20600-AD4W3	5019431	2	177	0	0
	MS21042L3	5037284	6	908	0	0
	NAS1149F0332P	5020603	12	2,453	0	0

Part Specifications

Specifications could not be found.

Plex 11/27/17 2:30 PM dart.poulin.mario

DOA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order: _____ Date: _____

Work Order update only

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DART
AEROSPACE
S036557



Long Basket Base Assembly, 350

PART NO: D3913-041

Original Serial #: S036557

Revision:

Operation:

Change No:

Start up Operation 01/29/18

Job No: 168954-A

DISPOSITION

AGAINST DEPARTMENT/PROCESS

Rework ☐
Scrap ☐
Re-as-is ☐
Proved ☐

Skid-tube ☐
Machining ☐
Thermoforming ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐
Composite ☐

Water Jet ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Supplier ☐

Engineering ☐
Quality ☐
Other ☐

QTY Effective :

Disposition

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

c
ave

Master Unit 000189



Job No 168954-A

Past Expiry Date	☐
Misidentified	☐
Manufacturing Process	☐
Past Due	☐
OTHER :	☐